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New patent claims

1. Header tube for a heat exchanger, with
- one or more slots (3a to 3d) for the insertion of a respective flat tube, said slots being introduced by punching with no inner die or by internal high-pressure forming, characterized in that
 - the ratio $(D/2s)$ of the tube outer radius $(D/2)$ to the tube-wall thickness (s) is lower than five.
2. Header tube according to Claim 1, further characterized in that the hardness of the material used for the header tube is between 35 HV and 80 HV.
3. Header tube according to Claim 1 or 2, further characterized in that the ratio $(D/D1)$ of the tube outside diameter (D) outside the slot regions to the tube transverse extent $(D1)$ in the slot regions is between 1.02 and 1.5.
4. Method for the production of a header tube with

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one or more slots for a heat exchanger, said slots being introduced by punching with no inner die or by internal high-pressure forming, characterized in that

- a flat piece (5) is bent into a header tube blank open along a longitudinal gap (8) and the longitudinal gap is subsequently sealingly soldered or sealingly welded, and
- the slot or slots (3a to 3d) are introduced into the header tube blank (6) after the longitudinal gap (8) is sealingly soldered or sealingly welded.

5. Method according to Claim 4, further characterized in that a solder-plated flat material is used as the flat piece (5).
6. Method according to Claim 5, further characterized in that the seal-soldering of the longitudinal gap (8) is carried out in a single soldering operation for the production of an associated heat exchanger, in which operation all the other soldered connections for constructing the heat exchanger are also made.

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7. Method according to one of Claims 4 to 6, further characterized in that punctiform heat treatment and/or mechanical weakening is provided at the points at which the slot or slots (3a) [sic] to 3d) are to be introduced.

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